

# Work Order ID 115282

March-24-14 10:02:04 AM

\*115282\*

REV 8 DAS 16 4/10/26  
9-89  
**PRELIMINARY ISSUE** Page 1

Item ID: D4542-1

Revision ID:

Item Name: Retainer, Inner, LH

Start Date: 3/24/14

Start Qty: 10.00

\*10\*

Required Date: 3/25/14

Req'd Qty: 10.00

\*10\*

Reference:

Accept

\*N900040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan: *[Signature]*

Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

DAS  
27  
9-89

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

9-89

D4542

PE 2

*[Signature]*

DAS  
10  
9-89

0.00

0.00

0.00

0.00

100

\*100\*

Waterjet

FLOW CNC Waterjet

Memo

1- Cut as per dwg

Prog rev: *PE 2*

Dwg rev: *PE 2*

2- Deburr

110

QC2- Inspect parts off machine FAI/FAIB

\*110\*

QC

Quality Control

Memo

10 0 14-03-25

10 0 14-03-25

# Work Order ID 115282

March-24-14 10:02:04 AM

**\*115282\***

Page 2

Item ID: D4542-1  
 Revision ID:  
 Item Name: Retainer, Inner, LH  
 Start Date: 3/24/14 Start Qty: 10.00 **\*10\***  
 Required Date: 3/25/14 Req'd Qty: 10.00 **\*10\***  
 Reference:

Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Stop **\*NS2\***  
 Cust Item ID:  
 Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
121- Alidan as per 052005-10 7/14/3-26									
122- Oct engine									
130	Identify as per dwg & Stock Location: _____	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

MAR 27 2014

DAS  
06  
9-89

POSITIVE RECALL

EFFECTIVE

RELEASED

DATE 14/03/26  
 AUTH                       
 Release DWS as per DWS  
 Rev E

DAS  
27  
9-89

# Picklist Print

March-24-14 10:02:03 AM

Page 1

Work Order ID: 115282

\*115282\*

Parent Item: D4542-1

\*D4542-1\*

Parent Item Name: Retainer, Inner, LH

Start Date: 3/24/14

Required Date: 3/25/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD  
REV:B 12.02.24 as per dwg reva DD verf:EC  
12.05.08 as per dwg revB DD verf:EC  
per dwg revD DD verf:JLM  
IPP  
IPP REV:C  
IPP REV:D 13.04.23 as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.032

Purchased

No

100

sf

401.2832

0.833

9

\*M6061T6S 0.032\*

6061-T6 Sheet 0.032"

\*\*

Jm 03-25

## Location

MAT021

## Loc Qty

401.28317

123483

8.57

m125822

17

m127272

119.43317

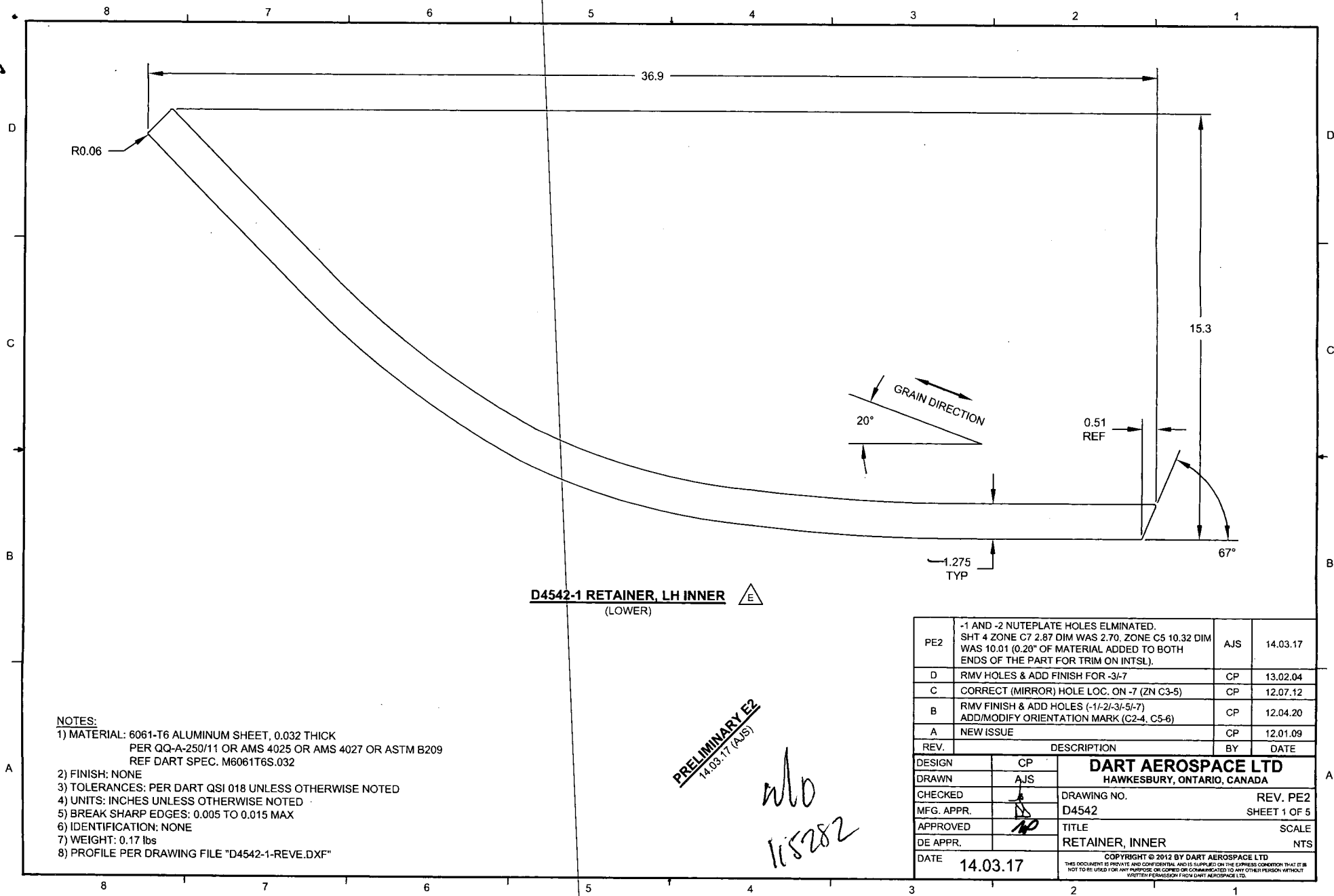
m128054

256.28

## Loc Code

128054








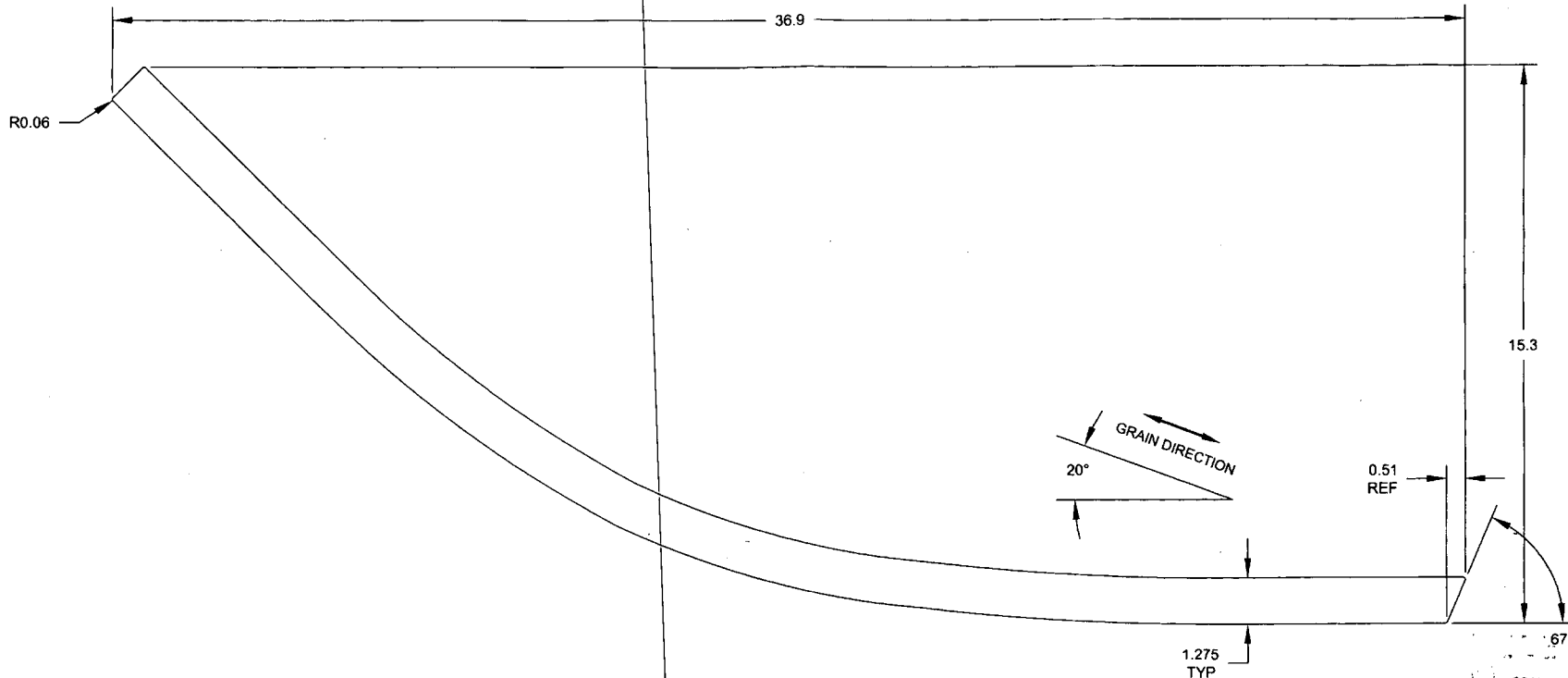
**D4542-1 RETAINER, LH INNER**  
(LOWER) E

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC. M6061T6S.032
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.17 lbs
  - 8) PROFILE PER DRAWING FILE "D4542-1-REVE.DXF"

**PRELIMINARY E2**  
14.03.17 (AJS)

*WLO*  
*115282*




PE2	-1 AND -2 NUTEPLATE HOLES ELIMINATED. SHT 4 ZONE C7 2.87 DIM WAS 2.70. ZONE C5 10.32 DIM WAS 10.01 (0.20" OF MATERIAL ADDED TO BOTH ENDS OF THE PART FOR TRIM ON INTSL).		AJS	14.03.17
D	RMV HOLES & ADD FINISH FOR -3/-7		CP	13.02.04
C	CORRECT (MIRROR) HOLE LOC. ON -7 (ZN C3-5)		CP	12.07.12
B	RMV FINISH & ADD HOLES (-1/-2/-3/-5/-7) ADD/MODIFY ORIENTATION MARK (C2-4, C5-6)		CP	12.04.20
A	NEW ISSUE		CP	12.01.09
REV.	DESCRIPTION		BY	DATE
DESIGN		CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		AJS		
CHECKED			DRAWING NO.	
MFG. APPR.			REV. PE2	
APPROVED			SHEET 1 OF 5	
DE APPR.			TITLE	
			SCALE	
			NTS	
DATE		14.03.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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**D4542-1 RETAINER, LH INNER**   
(LOWER)

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DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		<b>RETAINER, INNER</b> SCALE NTS	
DATE	14.03.17		

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